

5/11/10  
Work Order ID 58502 - 2

Friday, May 07, 2010 2:30:01 PM



Page 1

Item ID: D3908-041

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug Assembly, Aft

Stop



Start Date: 5/10/2010 Start Qty: 6.00

Required Date: 5/13/2010 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-5-7

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3908

B

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg  
TRIM RIVETS 1.185" LONG

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

EP 10/05/12 (6)

EP 10/05/12 (6)

~~Subtest 12~~

5/10/13

(+6)

+2





# Work Order ID 58502

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Page 2

Item ID: D3908-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug Assembly, Aft

Start Date: 5/10/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 5/13/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location: 506

0.00

Memo

0.00

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*PC 14/13 (2)*

*10/05/17*

*mf*

*10-5-14*





# Picklist Print

Friday, May 07, 2010 2:30:00 PM

Page 1

Work Order ID: 58502

Parent Item: D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft

Comments: IPP RevA: New issue DD verified by:EC  
As per Rev B 10-04-06 VERIFIED BY:DD





IPP REVB:

Start Date: 5/10/2010

Required Date: 5/13/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D2690-6  Lanyard Assembly		Manufactured	No			100	Each	0.0000	1			
D3908-1  Lug Plate, Aft Crosstube		Manufactured	No			100	Each	35.0000	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST095		35						
				57815		7						
				58344		28						
D3908-3  Stud Receiver, Lower		Manufactured	No			100	Each	2.0000	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST095		2						
				57816		2						
D3908-5  Eyebolt Stud		Manufactured	No			100	Each	13.0000	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				GA		1						
				57428		1						
				ST095		12						
				58347		12						

B58375 (62)

5/10/05/12

5/10/05/12

12

5/10/05/12

B58345 (62)

5/10/05/12

6





# Picklist Print

Friday, May 07, 2010 2:30:00 PM

Work Order ID: 58502



Parent Item: D3908-041



Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 5/10/2010

Required Date: 5/13/2010

Comments: IPP RevA: New issue DD verified by:EC  
As per Rev B 10-04-06 VERIFIED BY:DD

IPP REV B:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D3910-1		Manufactured	No			100	Each	12.0000	2			



Crosstube Lug

2  
9/5/05/12

Location	Loc Qty	Loc Code
ENG	11	
57194	11	
st507	1	
58353	1	

AN3C12A

Purchased

No

100

Each

176.0000

4



Bolts

4  
9/5/05/12

Location	Loc Qty	Loc Code
ST351	176	
112314	176	

MS17984-C413

Purchased

No

100

Each

27.0000

1



PIN, QUICK RELEASE

1  
9/5/05/12

Location	Loc Qty	Loc Code
ST297	4	
114340	4	
ST314	23	
114495	3	
114523	20	

6

358341 (22)





# Picklist Print

Friday, May 07, 2010 2:30:01 PM

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Work Order ID: 58502

Parent Item: D3908-041

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Comments: IPP RevA: New issue DD verified by:EC  
As per Rev B 10-04-06 VERIFIED BY:DD

IPP REV B:

Start Date: 5/10/2010

Required Date: 5/13/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

MS20615-4420 4418



RIVET

M114506

(364)

Purchased

No

100

Each

204.0000

6



EP 10/05/12

Location

Loc Qty

Loc Code

ST323

204

113254

16

114324

4

114349

184

MS21043-3



Nut

Purchased

No

100

Each

3,735.000

4



EP 10/05/12

Location

Loc Qty

Loc Code

FG

80

103691

80

ST301

3655

112314

3655

NAS1149C0332R



Washer

Purchased

No

100

Each

3,238.000

8



EP 10/05/12

Location

Loc Qty

Loc Code

ST297

3238

113524

10

113737

150

114341

3078

48

Friday, May 07, 2010 2:30:01 PM

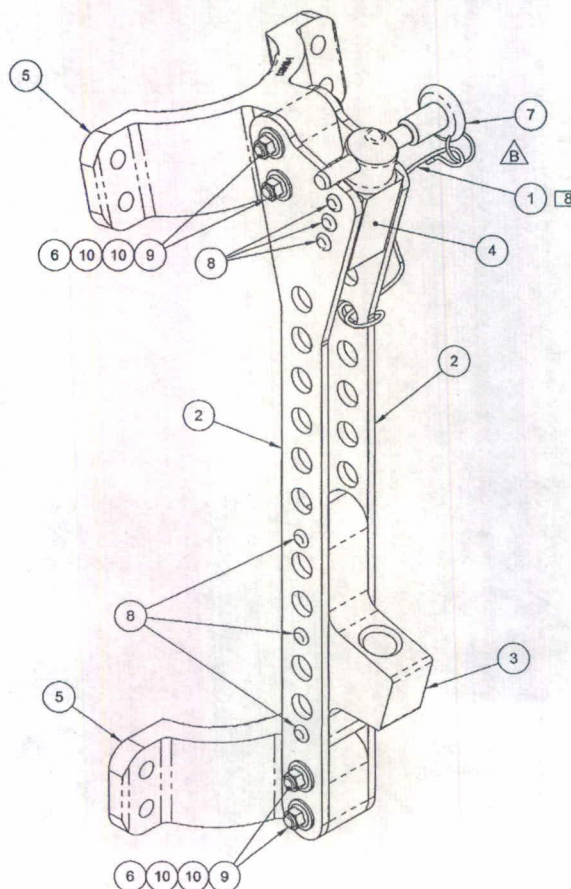
Shop Packet Print

Page 3





ITEM	QTY.	P/N	DESCRIPTION
	X	D3908-041	X-TUBE LUG ASSY (AFT)
1	1	D2690-6	LANYARD
2	2	D3908-1	AFT X-TUBE LUG PLATE
3	1	D3908-3	STUD RECEIVER LOWER
4	1	D3908-5	EYEBOLT STUD
5	2	D3910-1	X-TUBE LUG
6	4	AN3C12A	BOLT
7	1	MS17984-C413	PIP PIN
8	6	MS20615-4M20	RIVET
9	4	MS21043-3	NUT
10	8	NAS1149C0332R	WASHER



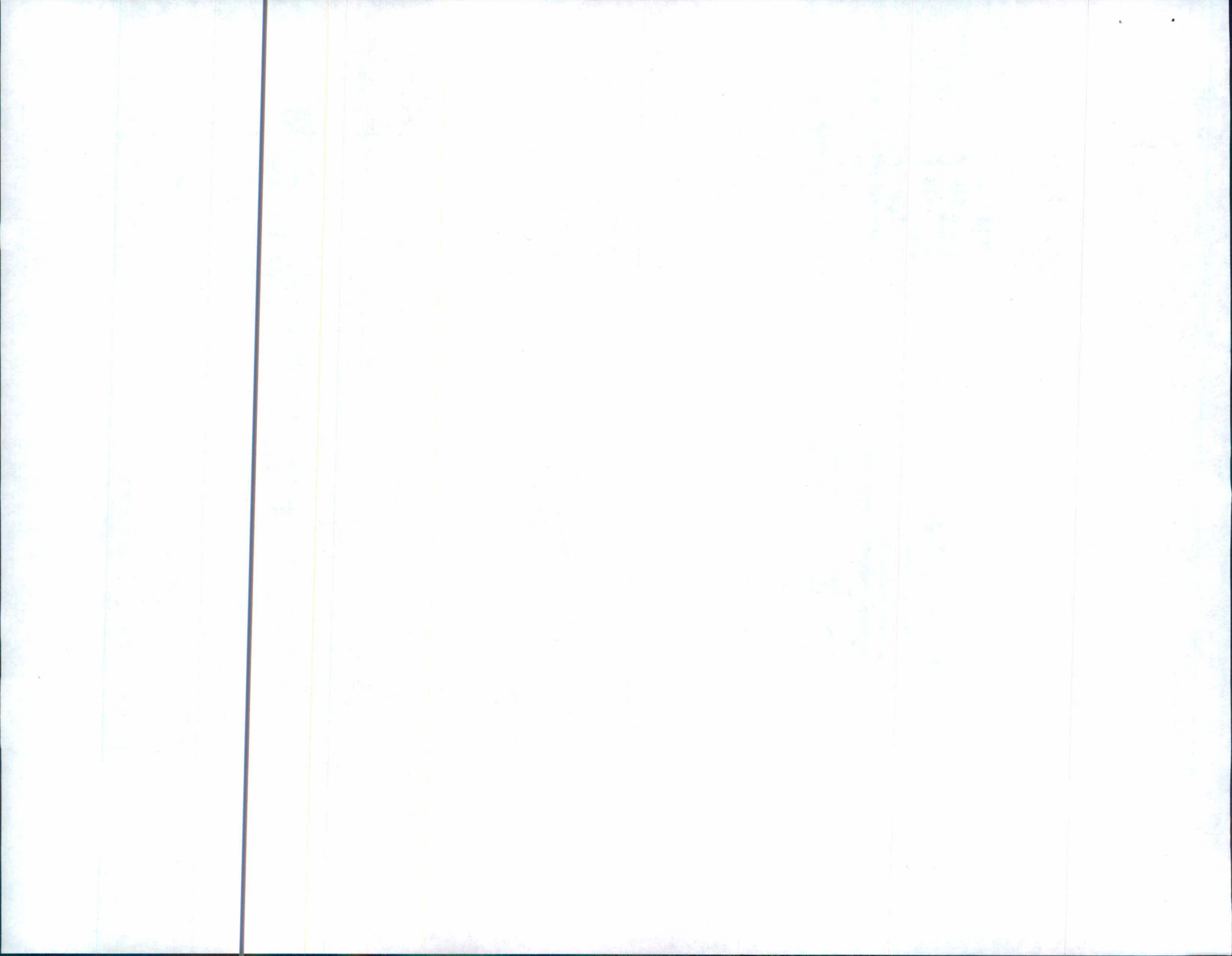
**D3908-041 X-TUBE LUG ASSY (AFT)**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3908-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.35 lbs
- 8) ATTACH TO D3908-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING.

**RELEASED**  
2010-04-14  
MP

B	BOM: D3909-5 REPLACED WITH D3908-5. QTY 1 ADDED: D2690-6 & MS17984-C413. SHEET 5: ADDED D3908-5	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH	DRAWING NO.	REV. B
CHECKED	JPH	D3908	SHEET 1 OF 5
MFG. APPR.	JPH	TITLE	SCALE
APPROVED	JPH	X-TUBE LUG ASSY (AFT)	NTS
DE APPR.	JPH	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.04.06		





8 7 6 5 4 3 2 1

D

C

B

A

D

C

B

A

D3908-5  
EYEBOLT STUD

D3910-1  
X-TUBE LUG  
2 PL

MS17984-C413  
PIP PIN

D2690-6  
LANYARD

D3908-1  
AFT X-TUBE LUG PLATE  
2 PL

AN3C12A BOLT  
NAS1149C0332R WASHER, 2X  
MS21043-3 NUT  
4 PL

D3908-3  
STUD RECEIVER LOWER

MS20615-4M20  
RIVET  
6 PL

7.114

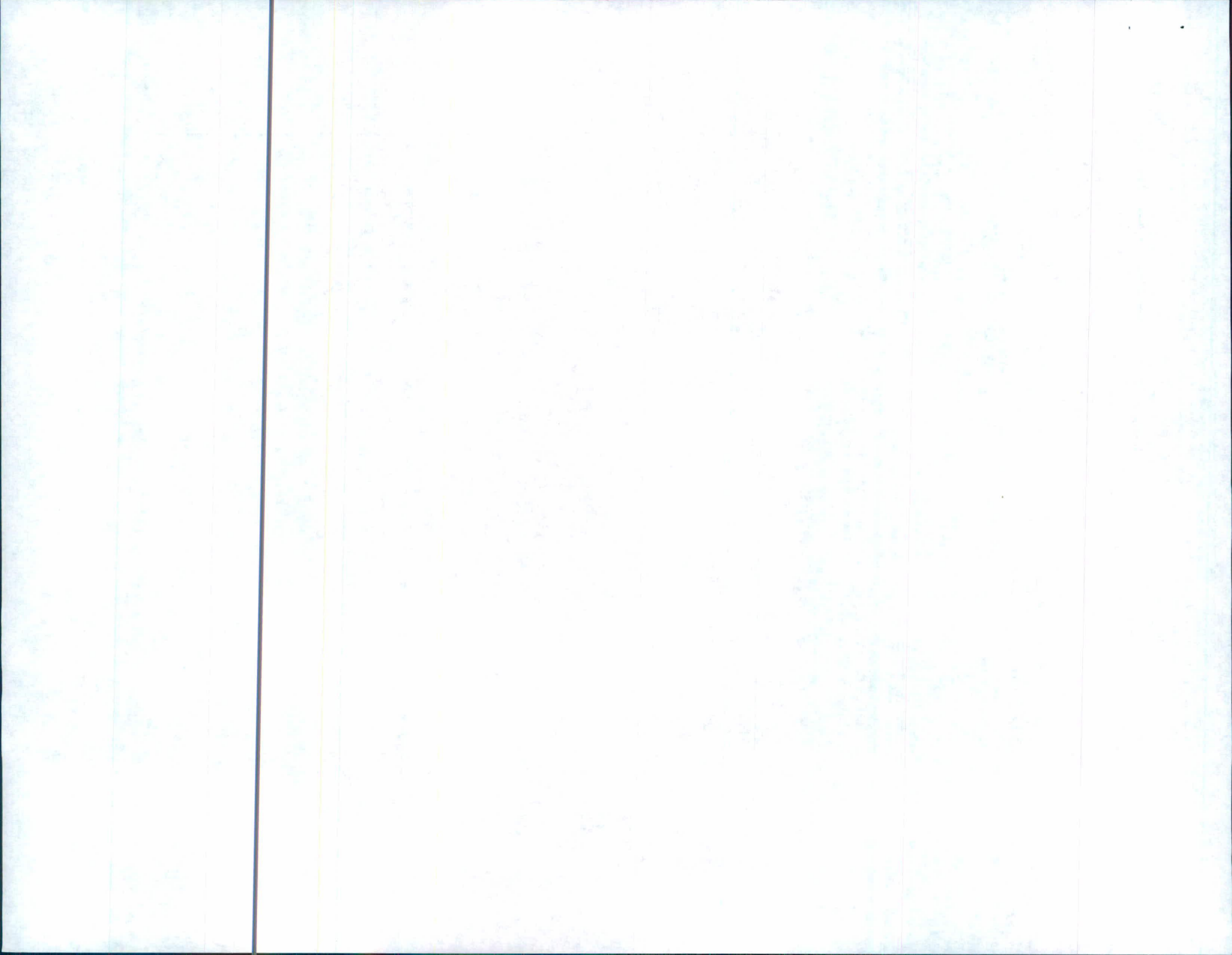
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**RELEASED**  
2010-04-14  
MD

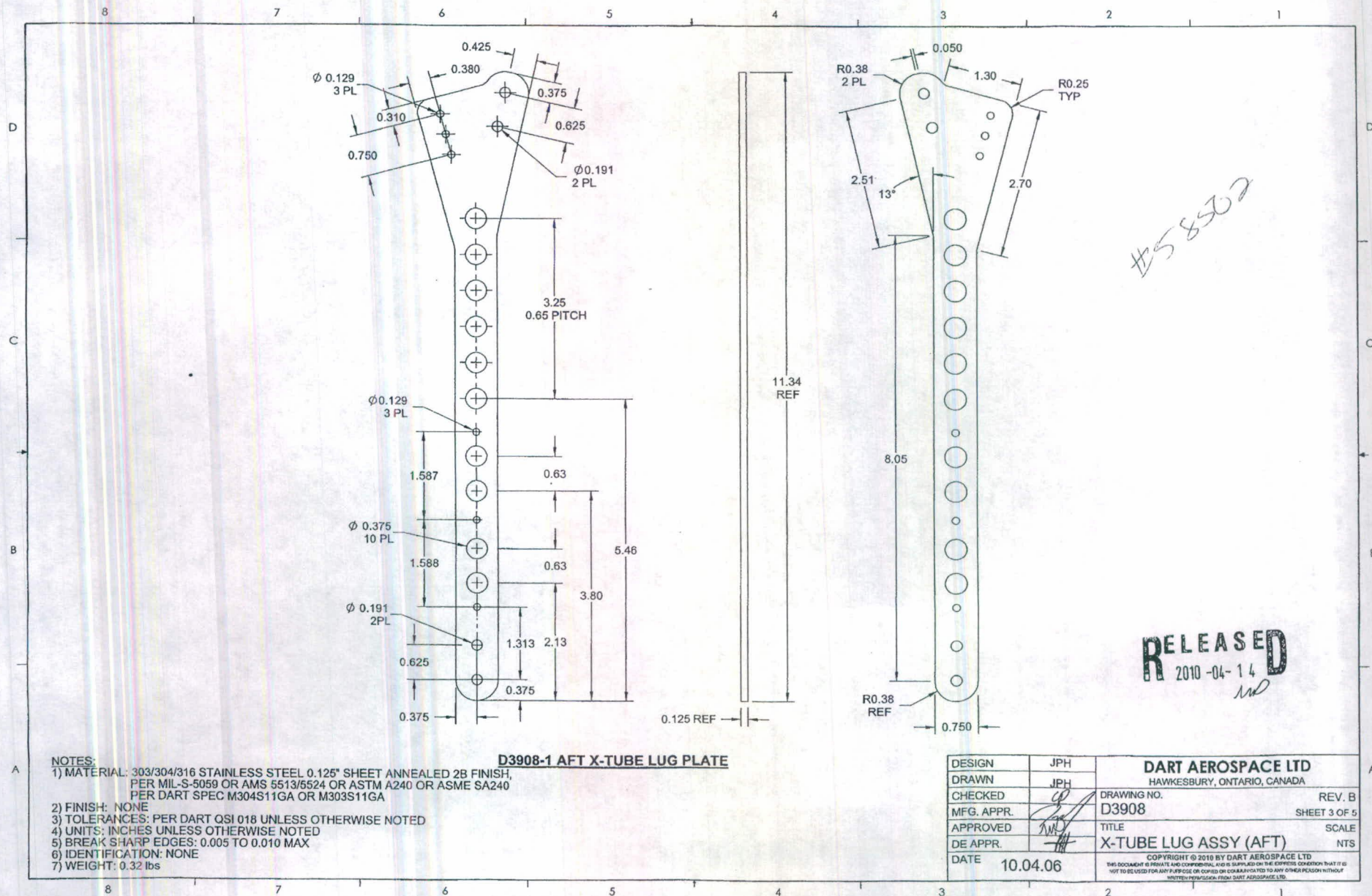
**D3908-041 X-TUBE LUG ASSY (AFT)**

DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO. <b>D3908</b>	REV. B
MFG. APPR.		TITLE	SHEET 2 OF 5
APPROVED		<b>X-TUBE LUG ASSY (AFT)</b>	SCALE
DE APPR.			NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

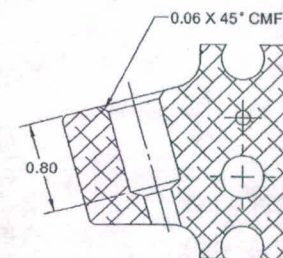
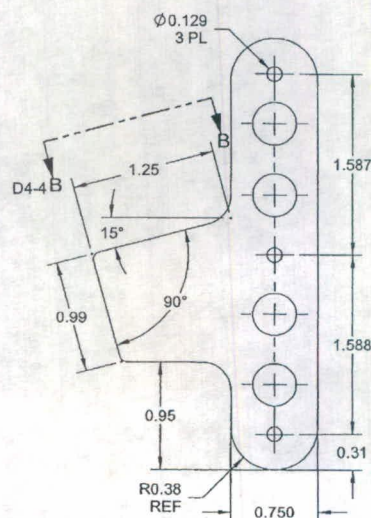
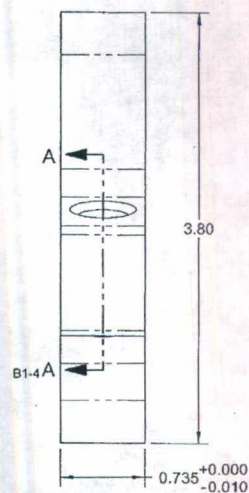
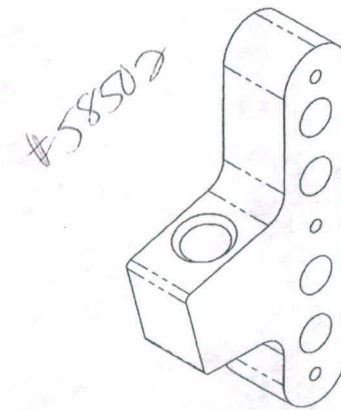
















RELEASED  
2010-04-14  
MP

NOTES:

- |            |   |   |              |
|------------|---|---|--------------|
| DESIGN     | JPH   | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA<br><br>DRAWING NO.<br><b>D3908</b><br><br>TITLE<br><b>X-TUBE LUG ASSY (AFT)</b><br><br>COPYRIGHT © 2010 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND UNCLASSIFIED. NO PART OF THIS DOCUMENT IS TO BE REPRODUCED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD. | REV. E       |
| DRAWN      | JPH   |   | SHEET 4 OF 4 |
| CHECKED    |  |   | SCALE        |
| MFG. APPR. |  |   | NTS          |
| APPROVED   |  |   |              |
| DE APPR.   |  |   |              |
| DATE       | 10.04.06  |   |              |

